



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE117-11181W1-25
Job Sheet 172035



Part No: RBE117-11181W1-25

Job Qty: 5 ea

5062070

Part Name: Contents Placard



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg RBE117-11181W1-25 Rev1 IPP RevA New issue 18/02/08 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		2/22/18	0.00	0.00	Start Up Small Fab-3		MCC
110	Small Fab	5 pcs		2/23/18	0.00	2.03	Small Fab-4		MCC DAS
120	QC	5 pcs		2/23/18	0.00	0.00	QC5		38
130	Packaging	5 pcs		2/23/18	0.00	0.00	Packaging3-1		9-89 18-04-18 DB
140	QC21-SA	5 Ea		2/23/18	0.00	0.00	QC21-mf 18/04/18		GA/34 DB

Part Op 110 - 1-Engrave placard using Laser engraver as per DWG. Sheet 14. ***NOTE*** Use PDF

Descriptions: 120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

DAS
21
9-89

APR 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
LM922402	Plastic, Black & White	1.2450 sf (.249 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	LM922402	1	48	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

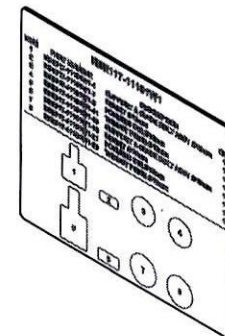
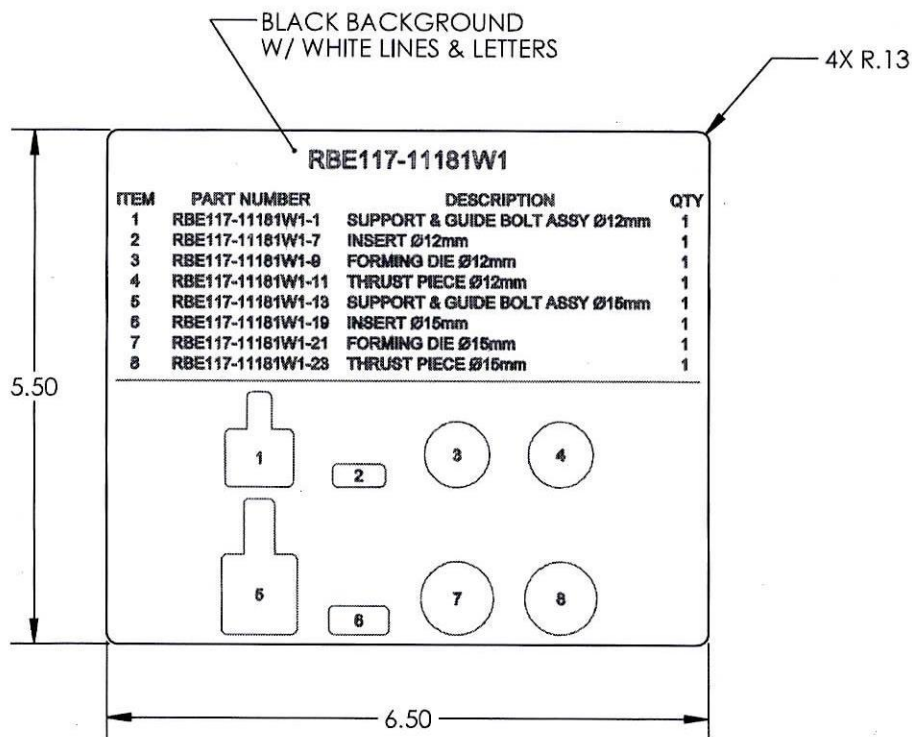
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 172031 MW
180212

NOTE:
USE PDF.

DART AEROSPACE	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-25	REV 1
MATERIAL PLASTIC	
TREAT FINISH	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 06/29/2017	USED ON MODEL
CHECKED: RJC 06/30/2017	SEE NOTE 3, SHEET 1
OPPS APPR: AA 07/10/2017	
QA APPR: JL 07/10/2017	
APPROVED: JAG 07/19/2017	
SCALE 1:2	DATE 6/29/2017
SHEET 14 OF 16	

(25)

CONTENTS PLACARD

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
WORK ORDER NO. 12345 DATE 12/12/2012 PART NO. 12345 NCR NO. 12345 DESCRIPTION WORK ORDER NO. 12345 DATE 12/12/2012 PART NO. 12345 NCR NO. 12345 DESCRIPTION WORK ORDER NO. 12345 DATE 12/12/2012 PART NO. 12345 NCR NO. 12345 DESCRIPTION				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

002553



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D2582**Job Sheet 172066****Part No:** D2582**Job Qty:** 8 ea**Part Name:** Hi-Skid Step Leg Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 2/12/18**Job Tracking No:****Due Date:** 2/19/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:**

Note: DWG REV B IPP Rev:F Removed Manufacturing 05-11-07 JLM IPP Rev:G Added part # to Sub 06-08-10 JLM
IPP Rev H New pick list 08.01.11 EC verified by: DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	2/17/18	2/17/18	0.00	0.00	Start Up Small Fab		
100	Small Fab	8 pcs	2/19/18	2/19/18	0.00	2.20	Small Fab		
110	QC	8 pcs	2/19/18	2/19/18	0.00	0.00	QC5		
120	Packaging	8 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3		
130	QC21-SA	8 Ea	2/19/18	2/19/18	0.00	0.00	QC21		

Part Op 100 - Assemble as per Dwg D2582 and
Descriptions: 120 - LOCATION WA003

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9-80

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2278	Step Leg	16 Ea (2 ea)	90-Start up Operation	F163480 1x S 060380 19x
D2279	Step Spacer	8 Ea (1 ea)	90-Start up Operation	F165348 2x F16334-222 3x
D2322	Step Spacer	8 Ea (1 ea)	90-Start up Operation	5000622 1x F163709 3x S030597 6x
D3720-1	Step Spacer	8 Ea (1 ea)	90-Start up Operation	F16631
D3720-2	Step Spacer	8 Ea (1 ea)	90-Start up Operation	F162902 2x S054843 8x
MS20470AD4-4	Rivet, Universal Head	176 Ea (22 ea)	90-Start up Operation	S045861
MS20470AD4-5	Rivet, Universal Head	32 Ea (4 ea)	90-Start up Operation	S049829

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2278	16	1	0
	D2279	8	14	0
	D2322	8	14	0
	D3720-1	8	19	0
	D3720-2	8	2	0
	MS20470AD4-4	176	2,636	0
	MS20470AD4-5	32	1,602	0

Part Specifications

Specifications could not be found.

Plex 2/12/18 1:01 PM Dart.Gagnon.Michelle



Container No: S061599



Part: D2582

Job No: 172066

Serial No/Batch: S061599

Revision:

Inspector:

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Date: 04/17/18